

Page 1

December 8, 2009 11:24:22 AM Accept Setup Start Item ID: D3763-3 **Revision ID:** Stop Item Name: Tube **Start Qty: 40.00 Cust Item ID: Start Date:** 08/12/2009 Req'd Qty: 40.00 **Required Date: 15/12/2009 Customer:** Reference: Start Run Date 01/2 **Tooling:** Date: **Process Plan:** Approvals: Stop Date: SPC (Y/N): Date: QC: Set Up/ Draw Plan Accept Reject Reject Insp. Operation Draw Sequence ID/ Code Qty Qty Number Stamp Number Rev. **Run Hours** Work Center ID Description **Revision Nbr Draw Nbr** D3763 Rev B 0.00 100 DOOSAN LATHE Doosan & Dwg D3763 Rev: B 02-Deburr JL 09/12/27 Doosan Lathe per dwg D3763 0.00 JL 09/12/27 QC2- Inspect parts off machine FAI/FAIB 110 0.00 Memo Quality Control DP 09/12/28 120 QC8- Inspect parts - second check 0.00 Memo Quality Control

Dart A	Aeros	pace	Ltd
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W/O:			W	ORK ORDER CHANG	ES					
DATE	STEP	PRO	OCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	•	PAR #:	Fault Cat	egory:	_ NCR:	Yes N	lo DQA	\:	_ Date: _	
	R	esolution:	Dispositi	on:	QA: N	VC Clo	sed:		Date:	
NCR:		1	WORK ORI	DER NON-CONFORM	ANCE ((NCR)				
DATE	STEP	Description of NC	Description of NC Corrective Action			Section B Verifi			fication Approval	
		Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Section	on C	Chief Eng	QC Inspector
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	1									

NOTE: Date & initial all entries

Work Order ID 54367



Page 2

December 8, 2009 11:24:23 AM Accept Setup Start D3763-3 Item ID: **Revision ID:** Stop Tube Item Name: Start Qty: 40.00 Cust Item ID: **Start Date:** 08/12/2009 Re@'d Qty: 40.00 **Required Date: 15/12/2009** Customer: Reference: Run Start Tooling: Date: Approvals: Process Plan: Date: Stop Date:_ SPC (Y/N): Date: QC: Plan Reject Reject Set Up/ Draw Draw Accept Operation Sequence ID/ Number Rev. Code Qty Qty Number Description Work Center ID **Run Hours** Identify as per dwg & Stock Location: 25/ 0.00 130 0.00 Packaging Memo Packaging

140

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/01/06/95/ MF 10-01-05

Insp.

Stamp

Da	art	Aer	OS	pac	e L	td

W/O:			W	ORK ORDER CHANG	ES					
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
•										
			•							
		,				•				
Part No	:	PAR #:	Fault Cate	gory:	_ NCR: Yes	No DQ	A :	_ Date: _		
	Res	olution:	Dispositio	n:	_ QA: N/C C	osed:		Date: _		
NCR:		,	WORK ORD	ER NON-CONFORM	ANCE (NCF	R)				
DATE	STEP	Description of NC	SCRIPTION OF NC			Section B Verifi			Approval	
	0.2.	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	Sect	ion C	Chief Eng	QC Inspector	
					1					

NOTE: Date & initial all entries

Picklist Print

December 8, 2009 11:24:26 AM

Work Order ID: 54367

Parent Item:

D3763-3

Parent Item Name: Tube



Start Date: 08/12/2009

Required Date: 15/12/2009

Page 1

Start Qty: 40.00

Required Qty: 40.00

Comments:						•	;	Start Qty: 40.00)	Required Qty: 4	40.00
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Primary Item Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status 3205
M6061T6R1.250		Purchased	No	1, 8, 10-1	100	f	28.1121	4.5895			

113457

6061-T6 Round Bar 1.250

Warehouse	Loc Oty	Loc Code
Location		
Main Warehouse		1
MAT	28.1121	
108876	9.6	
109733	7.04	
111321	9.1021	
18295	2.37	

H.589 JL 09/02/27

Dart Aerospace Ltd	Dart	Aer	osp	ace	Ltd
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W/O:			W	ORK ORDER CHAN	GES						
DATE	STEP	PR	OCEDURE CHA	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
									•		
		•									
		·							:		
·					,						
Part No	:	PAR #:	Fault Cate	gory:	NC	R: Yes	No DQ	A :	_ Date: _		
Resolution: Disposition: Q					QA	QA: N/C Closed: Date:					
NCR:			WORK ORD	ER NON-CONFORM	IANCE	(NCR)				
DATE	CTED	Description of NC			ction B	4	Verific	Verification App		Approval	
DATE ST	SIEP	STEP Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	1	Sign & Date	Secti		Chief Eng	QC Inspector	
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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	54367	
Description: Tube	Part Number:	D3763-3	
Inspection Dwg: D3763 Rev: B		Page 1 of 1	

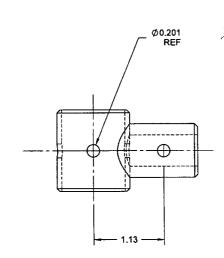
FIRST ARTICLE INSPECTION CHECKLIST

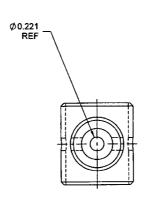
	X	First Artic	r—	Proto			
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Con	nments
Ø0.221	+0.005/-0.001						
0.66	+/-0.030				. \	20	
1.31	+/-0.030					7	
0.66	+/-0.030						
0.05 x 45°	+/-0.030 x +/-0.5°		1				
Ø0.201	+0.005/-0.001			\mathbb{N}	9		
Ø1.010	+0.010/-0.000		600				
Ø1.16	+/-0.030		9				
		MS	/				
	\cap	0					
	My						
<u> </u>							
							-
Measured by:	7	Audited by:	18		Prototype A	pproval:	N/A
Date:	09/12/27	Date:	09/12/	/27		Date:	N/A
Rev Date	Change		1 1		Revis	sed by	Approved
A 08.09.04	New Issue				NJ/DI	7 2,X)	

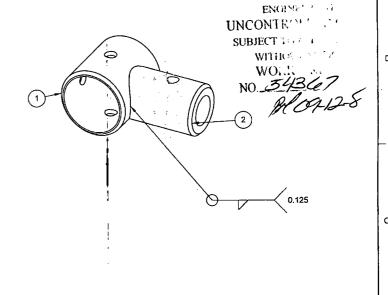
DART AEROSPACE LTD	Work Order:	54436
Description: Tube	. Part Number:	D3763-3
Inspection Dwg: D3763 Rev: B		Page 1 of 1

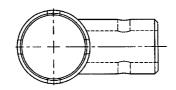
	FIRST	ARTICLE IN	SPECTIO	ON CHE	CKLIST	•	
	x	First Artic	le _	Proto	otype		
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method Inspec		nments
Ø0.221	+0.005/-0.001	.222					
0.66	+/-0.030	.655					
1.31	+/-0.030	1.309	/_				
0.66	+/-0.030	.654					
0.05 x 45°	+/-0.030 x +/-0.5°	.65x45°	<u>/</u>			·	· · · · · · · · · · · · · · · · · · ·
Ø0.201	+0.005/-0.001	-201					
Ø1.010	+0.010/-0.000	1.010	V				
Ø1.16	+/-0.030	1.160					
					Klim		
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			6				
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	,						. <u></u>
	5-)	Audited by:	28	7	Protot	type Approval:	N/A
Measured by:	20/10/27	Date:	07/12	127		Date:	N/A
Date:	09/12/27	Date.	0 1/ 12				Annroyed
Rev Date	Change					Revised by	Approved

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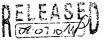






ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-041)
1	D3763-3	TUBE	1
2	D3763-1	FITTING	1

D3763-041 END FITTING ASSY

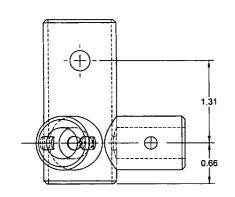


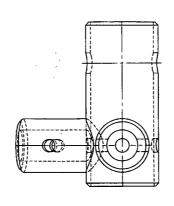
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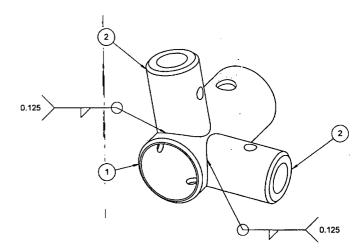
8	CHANGE HOLES SIZE, ADD -7 PART AND -045 ASSY		HS	08.06,23	
Α	NEW ISSUE		HS	08.06.04	
REV.	DESCRIPTION		BY	DATE	
DESIG	N	HS	DART AEROSE	ACE L	TD
DRAW	N	HS	HAWKESBURY, ONTA	RIO, CANA	DA
CHEC	(ED	PH.	DRAWING NO.		REV. B
MFG.	APPR.	$-\mathbf{Z}$	D3763		SHEET 1 OF 9
APPRO	OVED	-7M	TITLE		SCALE
DE AP	PR.	-#	END FITTING		NTS
DATE 08.06.23		6.23	COPYRIGHT © 2008 BY DAR THIS DOCUMENT IS PRINTE AND CONFIDENTIAL AND IS BUY NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMM	PLIED ON THE EXPRES	SE CONDITION THAT IT IS

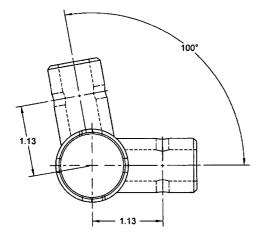
NOTES:
1) MATERIAL: N/A
2) FINISH: CHEMICAL CONVERSION COAT ASSEMBLY PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
S SOFAK OULDD SDOED A COS TO A DIA MANY

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX 5) IDENTIFICATION: N/A 7) WEIGHT: 0.03 lbs 8) WELD: PER DART QSI 004









ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-043)
1	D3763-5	TUBE	1
2	D3763-1	FITTING	2

D3763-043 END FITTING ASSY, LH

NOTES:

() MATERIAL: N/A

2) FINISH: CHEMICAL CONVERSION COAT ASSEMBLY PER DART QSI 005 4.1

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

1) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

5) IDENTIFICATION: N/A

7) WEIGHT: 0.05 lbs

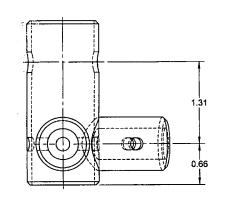
3) WELD: PER DART QSI 004

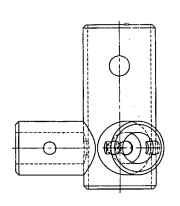
DESIGN HS DART AEROSPACE LTD DRAWN HS HAWKESBURY, ONTARIO, CANADA CHECKED DRAWING NO. REV. B D3763 MFG. APPR. SHEET 2 OF 9 TITLE APPROVED SCALE **END FITTING** DE APPR. NTS COPYRIGHT © 2008 BY DART AEROSPACE LTD

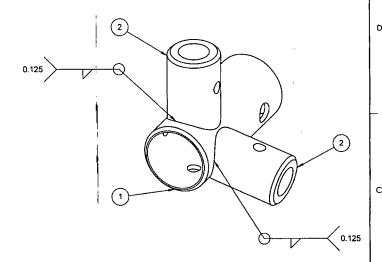
THE DOCUMENT BY PRINTE AND COMPETENDA, MODE SHAPE, DICH THE DOWNESS CONDITION THAT IS NOT TO BE VESTED FOR ANY PRINCE OF COURSE CONSTRUCTED ON ANY OTHER PRISON NAMED AND ANY ARROSPACE LTD.

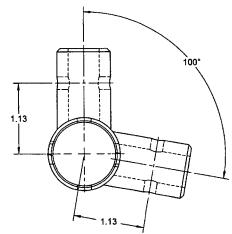
WHITTEN PRINCESON PRIOR DATA ARROSPACE LTD. DATE 08.06.23

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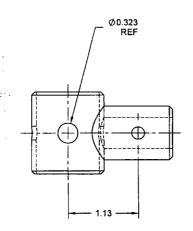
ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-044)
1	D3763-6	TUBE	1
2	D3763-1	FITTING	2

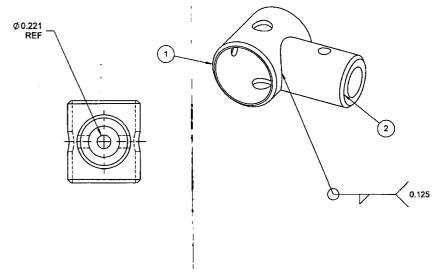
D3763-044 END FITTING ASSY, RH

6

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DESIGN HS DRAWN HS PH. CHECKED DRAWING NO. REV. B D3763 MFG. APPR. SHEET 3 OF 9 APPROVED TITLE SCALE **END FITTING** DE APPR. NTS COPYRIGHT 6 2008 BY DART AEROSPACE LTD
THE DOCUMENT IS PRINTE AND CONTRETTIN, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IS NOT TO BE USED FOR ANY PAPAGES OF COMMONICATE TO ANY OTHER PERSON WITCOME AF ARCHITECTURE ARCHITECTURE. DATE 08.06.23

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ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-045)
1	D3763-7	½ TUBE	1
2	D3763-1	FITTING	1

D3763-045 END FITTING ASSY

NOTES:
1) MATERIAL: N/A
2) FINISH: CHEMICAL CONVERSION COAT ASSEMBLY PER DART QSI 005 4.1
2) FOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.03 lbs
8) WELD: PER DART QSI 004

DESIGN HS DART AEROSPACE LTD DRAWN HS HAWKESBURY, ONTARIO, CANADA DRAWING NO. CHECKED REV. B D3763 MFG. APPR SHEET 4 OF 9 APPROVED TITLE SCALE **END FITTING** DE APPR. NTS COPYRIGHT © 2008 BY DART AEROSPACE LTD
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NOT TO BE USED FOR ANY PRAPOSE OR COMED OR SCHOOLAGE TO THAT OTHER PERSON WITHOUT
WRITTEN PERSONS OF FROM DART AEROSPACE LTD. DATE 08.06.23

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3

2

С

Ø 0.50 THRU R0.580-∠0.06 x 45° CHAMFER ALL AROUND Ø0.860^{+0.000} 1.090 Ø0.201 🛕 THRU -0.05 X 45° CHAMFER 0.545

D3763-1 FITTING

NOTES: 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ALUMINUM ROUND BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR PER AMS-QQ-A-200/8 (OR AMS 4160) (REF. DART SPEC M6061T6R)

(OR AMS 4117/4128/4115/4116) OR PER AMS-QQ-A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDEES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.02 lbs

8

DESIGN	HS	DART AEROSPA	ACE LTD
DRAWN	HS	HAWKESBURY, ONTAR	IO, CANADA
CHECKED	284/	DRAWING NO.	REV. B
MFG. APPR.	4/1	D3763	SHEET 5 OF 9
APPROVED	T /W/7	TITLE	SCALE
DE APPR.	-	END FITTING	NTS
DATE 08.	06.23	THE DOCUMENT IS PRIVATE AND CONTRIBUTION, AND IS SUPPLIED TO TO BE USED FOR ANY PURPOSE OR COPED OR COMMUNIC WRITTEN PERMISSION FROM DART AS	D ON THE EXPRESS CONDITION THAT IT IS CATED TO ANY OTHER PERSON WITHOUT

Ø1.010^{+0.010} Ø0.221 B 0.66 Ø1.16 B B 0.66 -0.05 X 45° CHAMFER 2 PL Ø0.201 THRU B

D3763-3 TUBE

W/o 54367

NOTES:

1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6510/T6511/T62) ALUMINUM ROUND BAR PER AMS-QQ-A-225/8
(OR AMS 4117/4128/4115/4116) OR PER AMS-QQ-A-200/8 (OR AMS 4160) (REF. DART SPEC M6061T6R)

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

3) IDENTIFICATION: N/A

7) WEIGHT: 0.01 lbs

5

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DESIGN	HS	DART AEROSPACE LTD	
DRAWN	HS	HAWKESBURY, ONTAR	IO, CANADA
CHECKED	18 1	DRAWING NO.	REV. B
MFG. APPR.	(Jull)	D3763	SHEET 6 OF 9
APPROVED	ANA	TITLE	SCALE
DE APPR.		END FITTING	NTS
DATE 08.06.23		COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND COMPOSITIVE AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMPED OR COMMUNICATED TO ANY DIRECT REPORT WITHOUT WRITTEN REPRESSION FROM DART ARROPACE (TD.)	

0.655 Ø0.323 THRU 2.62 ∞ 0.655 THRU B 0.05 X 45° CHAMFER-2 PL Ø1.010^{+0.010} D3763-5 TUBE

DART AERÓSPACE LTD DESIGN HS DRAWN HS HAWKESBURY, ONTARIO, CANADA DRAWING NO. CHECKED REV. B D3763 MFG. APPR. SHEET 7 OF 9 APPROVED TITLE **END FITTING** DE APPR. NTS COPYRIGHT © 2008 BY DART AEROSPACE LTD
THIS DOUBLET IS PRIVATE AND COMPOSITION AND IS UPPURED OF THE DIRECTS CONDITION THAT IT IS
NOT TO BE USED FOR ANY PAPOSE ON COMPLIANCE TO DAYS OTHER PERSON WITHOUT
WAITTON PERSONSON FROM DART ARRIPMOSE TY. DATE 08.06.23

OTES:
i) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6510/T6511/T62) ALUMINUM ROUND BAR PER AMS-QQ-A-225/8
(OR AMS 4117/4128/4115/4116) OR PER AMS-QQ-A-200/8 (OR AMS 4160) (REF. DART SPEC M6061T6R)

(OR AMS 417/4126/4115/4116) OR PER AMS-QQ-A

1) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

3) UNITS: INCHES UNLESS OTHERWISE NOTED

3) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

i) IDENTIFICATION: N/A
') WEIGHT: 0.02 lbs

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SCALE

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0.655 0 ∞ Ø0.221 THRU 2 PL 2.62 С 0.655 0.05 X 45° CHAMFER Ø0.323 THRU 2 PL Ø1.010^{+0.010} -0.000 — Ø1.16 **D3763-6 TUBE** DART AEROSPACE LTD DESIGN <u>IOTES:</u>
1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6510/T6511/T62) ALUMINUM ROUND BAR PER AMS-QQ-A-225/8
(OR AMS 4117/4128/4115/4116) OR PER AMS-QQ-A-200/8 (OR AMS 4160) (REF. DART SPEC M6061T6R) DRAWN HS HAWKESBURY, ONTARIO, CANADA DRAWING NO. CHECKED REV. B (OR AMS 4117/4128/4115/4116) OR PER AMS-QQ-/
!) FINISH: NONE
!) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
!) UNITS: INCHES UNLESS OTHERWISE NOTED
!) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
!) IDENTIFICATION: N/A

) WEIGHT: 0.02 lbs D3763 MFG. APPR. SHEET 8 OF 9 APPROVED TITLE SCALE **END FITTING** DE APPR. NTS COPYRIGHT © 2008 BY DART AEROSPACE LTD

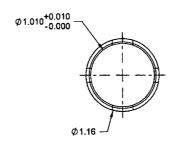
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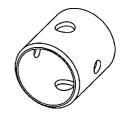
3

2

7

Ø0.221 THRU 0.66





-0.05 X 45° CHAMFER 2 PL 0.66 Ø0.323 THRU

D3763-7 TUBE 🛕

NOTES:
1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6510/T6510/T6511/T62) ALUMINUM ROUND BAR PER AMS-QQ-A-225/8
(OR AMS 4117/4128/4115/4116) OR PER AMS-QQ-A-200/8 (OR AMS 4160) (REF. DART SPEC M6061T6R)

6

(OR AMS 4117/4128/4115/4116) OR PER AMS-QQ-/
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.01 lbs

WIU 54367				
DESIGN	HS	DART AEROSPA	CE LTD	
DRAWN	HS	HAWKESBURY, ONTARK	D, CANADA	
CHECKED	85/	DRAWING NO.	REV. B	
MFG. APPR.	4/2/	D3763	SHEET 9 OF 9	
APPROVED	1	TITLE	SCALE	
DE APPR.		END FITTING	NTS	
DATE 08.06.23 COPYRIGHT © 2008 BY DART AFROSPACE LTD responses to many and expenses of the processing and th				